

# Work Order ID 69989

Wednesday, May 25, 2011 10:50:34 AM



Page 1

Item ID: D4353-041

Accept



Setup Start



Revision ID: ~~PRELIM~~

Stop



Item Name: Bearpaw Assembly

Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

*10525*

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4353

B

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D4353-1 File

*B11-6-9*

*(4)*

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining

2-Machine as per FolioFB050 and Dwg

FOLIO REV: *AA*

DWG REV: *B*

3-Deburr

*B.A 11/07/05*

*4*

*φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

[illegible]

Page 2

**Accept**

[illegible]**Setup Start**

**Stop**

[illegible]**Cust Item ID:****Customer:**

**Reference:**

Run Start

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop**

**Insp.  
Stamp**

B.A 11/07/06

\_\_\_\_\_

QC

## Memo

0.00

## Quality Control

0.00

[illegible]

QC

## Memo

0.00

## Quality Control

0.00



### Packaging

## Memo

0.00

## Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 69989

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Page 3

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Accept



Setup Start



Revision ID: ~~PRELIM~~

Stop



Item Name: Bearpaw Assembly

Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
153		0.00							
Small Fab	Memo	0.00	SB	11/07/07		(4)			
Small Fab	PRESS D4353-3 INSERT INTO BEARPAW								
154	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00	8 w/07/07			(74)			
Quality Control			Q Rev B Dm						
155	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo PP169986	0.00							
Packaging									

Rec'd 8/8 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**Work Order ID 69989**

Wednesday, May 25, 2011 10:50:34 AM



Page 4

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Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11

MF  
11-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Wednesday, May 25, 2011 10:50:41 AM

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**Required Date:** 6/3/2011

**Required Qty: 4.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No				sf	141.6000		20		B11-6-9	

**Loc Code**

0.0000

0.0000

[illegible]

### Bearpaw Insert

B 71095

117819

4

SB 11/07/07 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	69989
<b>Description:</b> BEARPAW ASSEMBLY	<b>Part Number:</b>	D4353-1
<b>Inspection Dwg:</b> D4353 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	+/- .030	0.380	✓		Vern	GA-01
7.375	+/- .010	7.370	✓		"	"
12.50	+/- .030	12.500	✓		Tape	GA-12
1.38	+/- .030	1.378	✓		Vern	GA-01
3.813	+/- .010	3.813	✓		"	"
24.00	+/- .030	24.00	✓		Tape	GA-12
10.09	+/- .030	10.088	✓		Vern	CNC-02
1.00	+/- .030	0.997	✓		Vern	GA-01
6.150	+/- .010	6.149	✓		Vern	CNC-02
3.038	+/- .010	3.038	✓		"	"
6.563	+/- .010	6.561	✓		"	"
9.250	+/- .010	9.250	✓		"	"
27.00	+/- .030	27.00	✓		"	"
1.25	+/- .030	1.252	✓		Vern	GA-01
0.30 x 45°	+/- .030	0.320 x 45°	✓		"	"
1.38	+/- .030	1.375	✓		"	"
0.63	+/- .030	0.625	✓		"	"
0.95	+/- .030	0.960	✓		"	"
R 0.25	+/- .030	R 0.250	✓		R-6	ref.
0.70	+/- .030	0.698	✓		Vern	GA-01
0.07 x 45°	+/- .030	0.072 x 45°	✓		"	"
φ 0.650	+/- .010	φ 0.651	✓		"	"
φ 0.261	+ .006 / - .001	φ 0.260	✓		"	"

<b>Measured by:</b> B.A	<b>Audited by:</b> <i>mf</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 11/07/06	<b>Date:</b> 11/07/06	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*10.04.15*

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 69989
<b>Description:</b> BEARPAW ASSEMBLY		<b>Part Number:</b> D4353-1
<b>Inspection Dwg:</b> D4353 <b>Rev:</b> B		<b>Page</b> 2 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/- .010	0.405	✓		D-6	GA-08
4.750	+ .0012 / - 0.000	4.7500	✓		Vein	GA-01
4.000	+ .0012 / - 0.000	4.0000	✓		"	"
5.75	+/- .030	5.755	✓		"	"
0.63	+/- .030	0.629	✓		"	"
0.57	+/- .030	0.580	✓		"	"
0.25	+/- .030	0.249	✓		"	"
0.45	+/- .030	0.455	✓		"	"
0.06x45°	+/- .030	0.050x45°	✓		"	"
R0.25	+/- .030	R0.250	✓		R-6	ref.

<b>Measured by:</b> A.A	<b>Audited by:</b> <i>mf</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 11/07/06	<b>Date:</b> 11/07/06	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

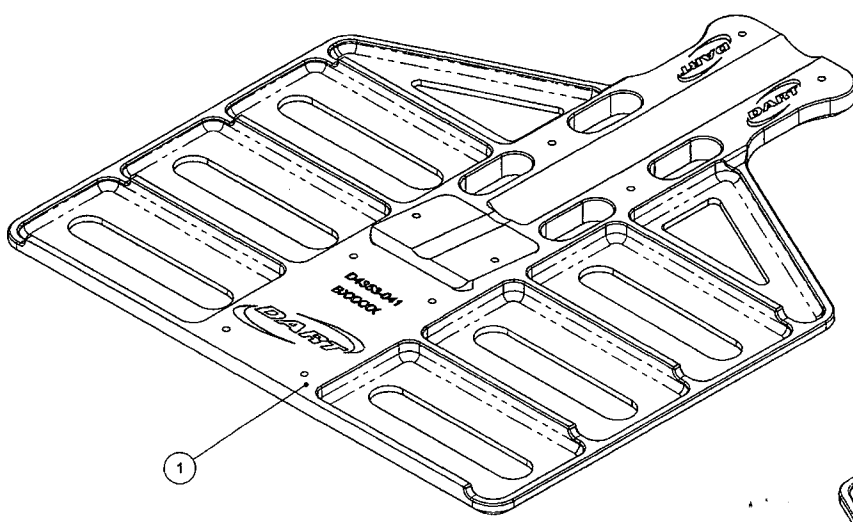
*10.04.15*

8 7 6 5 4 3 2 1

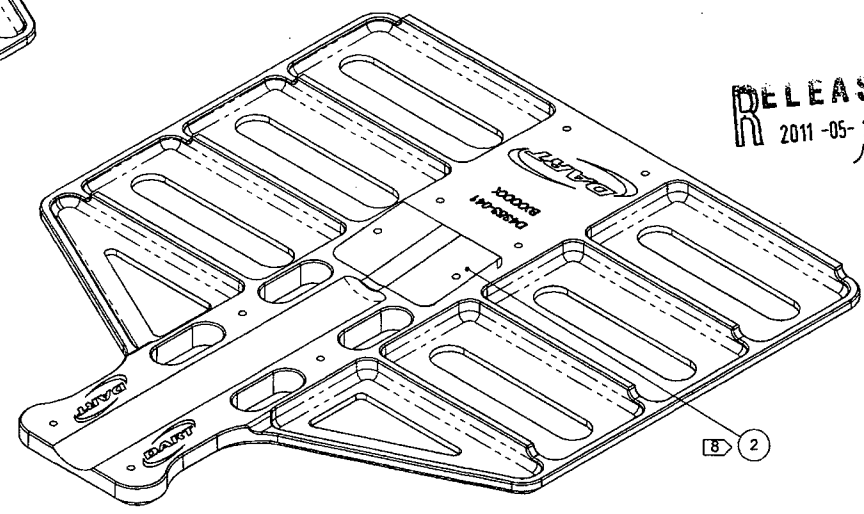
ITEM	QTY	P/N	DESCRIPTION
	X	D4353-041	429 BEARPAW ASSEMBLY
1	1	D4353-1	429 BEARPAW
2	1	D4353-3	429 BEARPAW INSERT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69989

*211-0525*



**D4353-041 429 BEARPAW ASSEMBLY**



**RELEASED**  
2011-05-24  
*NP*

- NOTES:**  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: N/A  
7) WEIGHT: 7.45 lbs  
8) PRESS FIT

B	SHT 1 WEIGHT CORRECTED WAS 8.24 lbs SHTS 1-3 DART LOGOS UPDATED. SHT 2, ZONE B8, AFT POCKET REDUCED. RIB INCREASED IN HEIGHT. SHT 3 SECTS. B,C & D RIB INCREASED IN HEIGHT.		AJS	11.04.26
A	NEW ISSUE		AJS	11.03.24
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	<i>NP</i>		DRAWING NO.	REV. B
MFG. APPR.	<i>NP</i>		D4353	SHEET 1 OF 4
APPROVED	<i>NP</i>		TITLE	SCALE
DE APPR.	<i>NP</i>	429 BEARPAW ASSEMBLY	NTS	
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

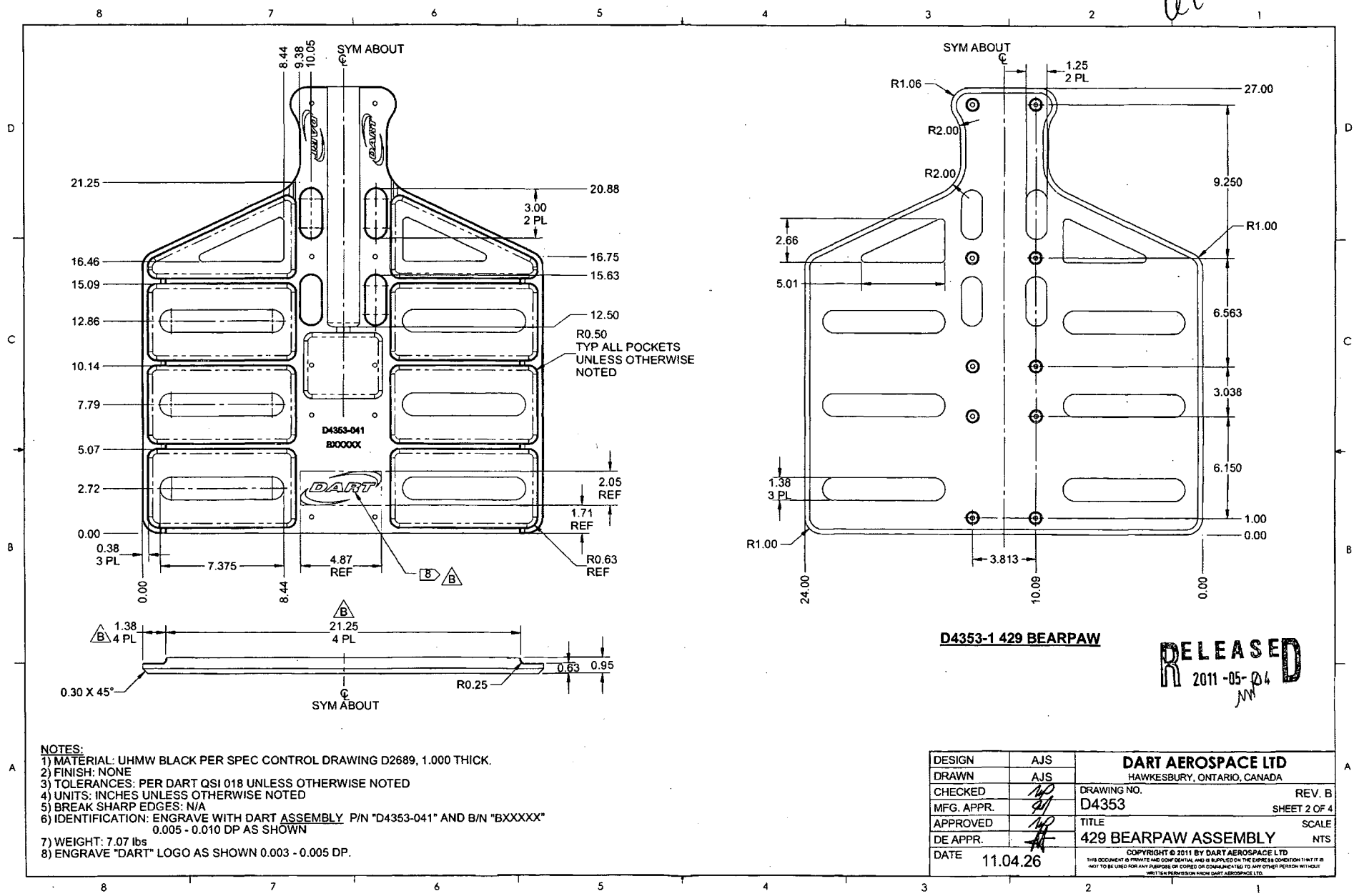
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

149989



D4353-1 429 BEARPAW

RELEASED  
2011-05-04

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4353	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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**NOTE:** Date & initial all entries



[illegible]

RELEASED  
2011-05-26  
JMD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

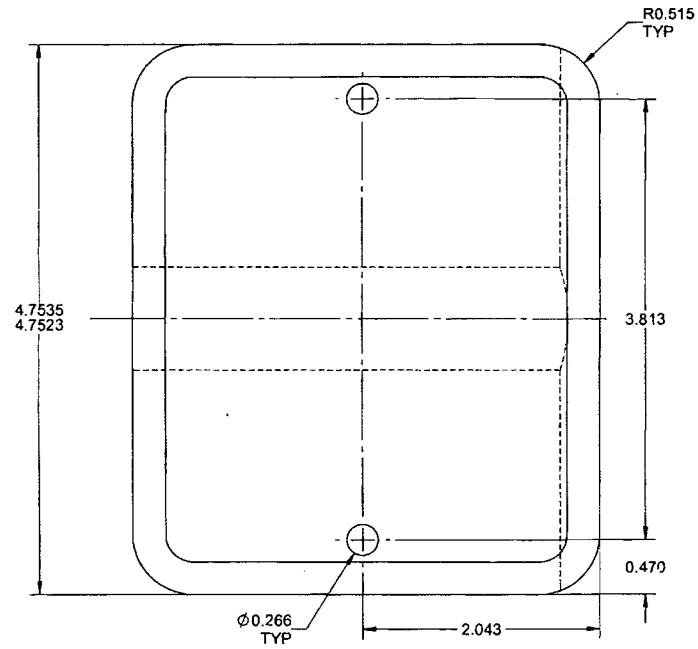
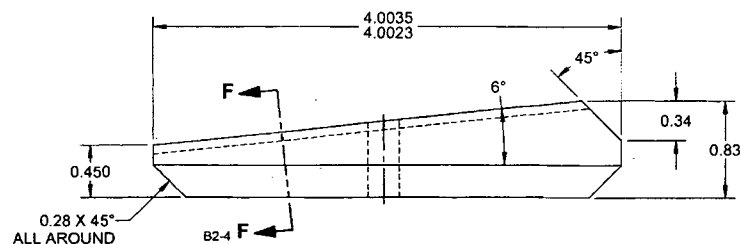
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

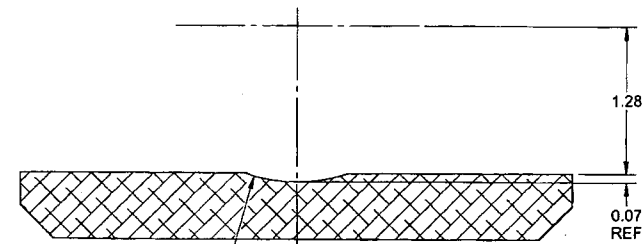
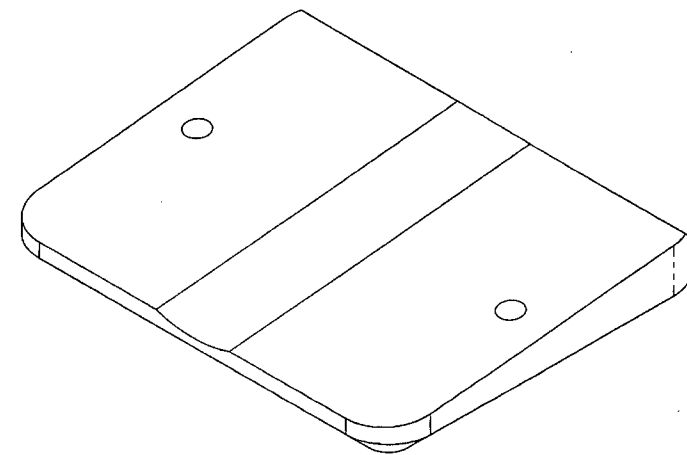
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

69989



**D4353-3 429 BEARPAW INSERT**



**SECTION F-F C7-4**

- NOTES:**
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.38 lbs

**RELEASED**  
2011-05-26

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4353	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries